

Work Order ID 61943 PRELIMINARY ISSUE

Monday, September 13, 2010 8:18:14 AM

Page 1

Item ID: D4172-7

Revision ID: PRELIM

Item Name: Crossbar

Start Date: 9/10/2010

Start Qty: 600 5

Accept



Setup Start



Required Date: 9/17/2010

Req'd Qty: 600 5



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:



Date: 10-9-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4172

PAT PA2

100



Small Fab

Memo

0.00

- 1- Cut to lenght as per dwg
- 2- Use DT9661 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

110



QC5- Inspect part completeness to step on W/O

0.00 - Inspect to PA2

Do only

8/10/13 (5)

QC

Quality Control

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

2) 10 10/13

5 01

Hand Finishing

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4172-7

Revision ID: PRELIM

Item Name: Crossbar

Start Date: 9/10/2010 Start Qty: 6.00

Required Date: 9/17/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: Lower Racks

0.00

ZT 10-09-21 K5

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/29 HJMF
10-9-21

POSITIVE RECALL

EFFECTIVE 10-09-21RELEASED 10-09-21

MFG

DATE 10-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61943



Parent Item: D4172-7



Parent Item Name: Crossbar

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125 6061T6 ANGLE 1.00 x 1.00 x .125W		Purchased		No		100	f	0.0000	1.3453	8.496632			

D6201 B46909
3X
2x M115688
M116909
10.09.20

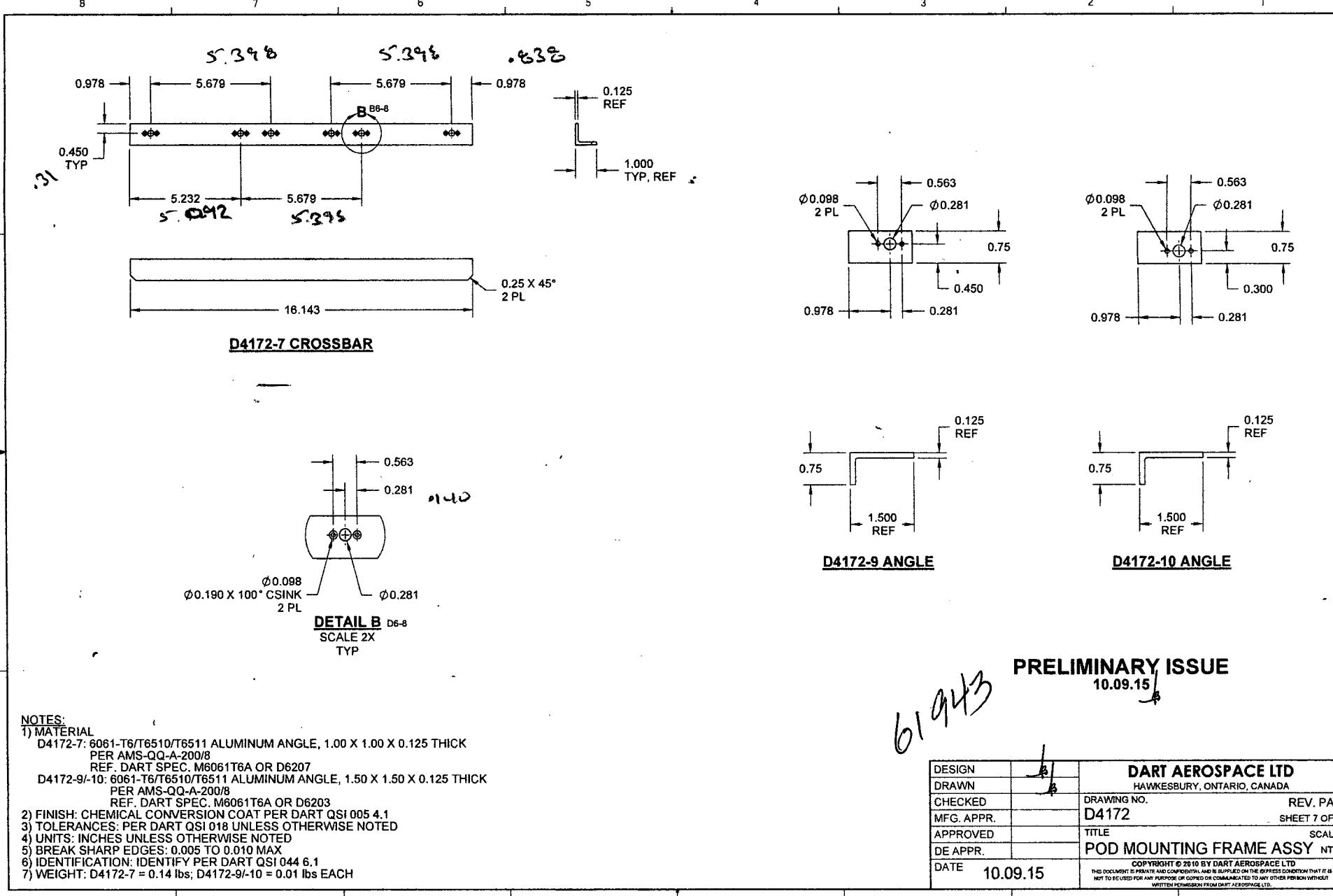
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

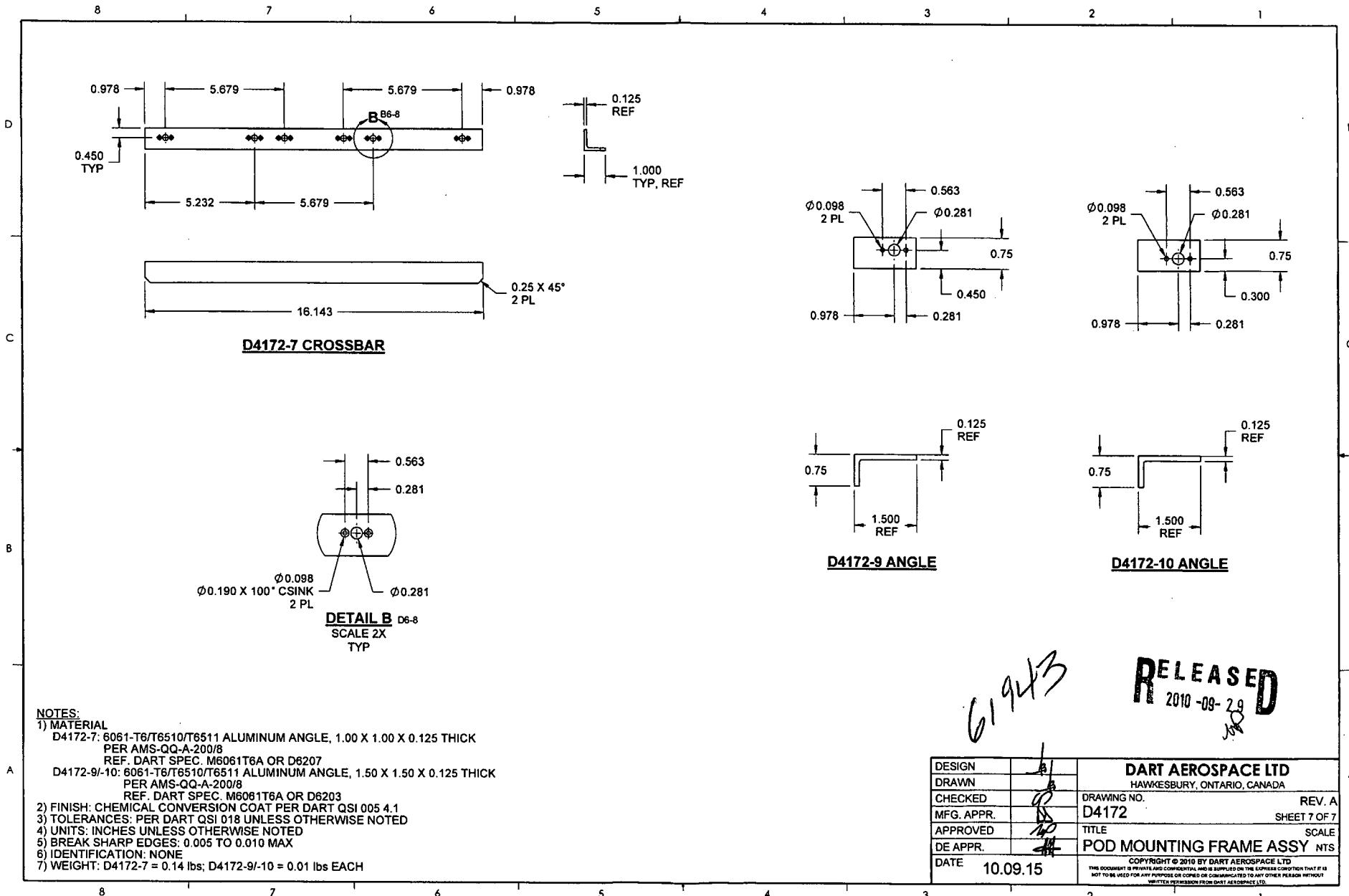
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





NOTES:

1) MATERIAL: D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

RELEASED
2010-09-29

DESIGN	<u>A</u>	DART AEROSPACE LTD		
DRAWN	<u>B</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>C</u>	DRAWING NO.	REV. A	
MFG. APPR.	<u>D</u>	D4172	SHEET 7 OF 7	
APPROVED	<u>E</u>	TITLE	SCALE	
DE APPR.	<u>F</u>	POD MOUNTING FRAME ASSY	NTS	
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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